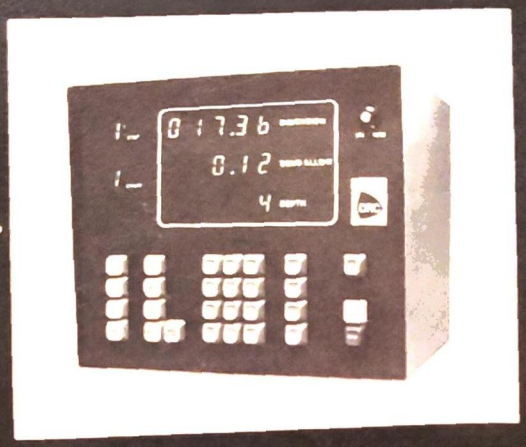
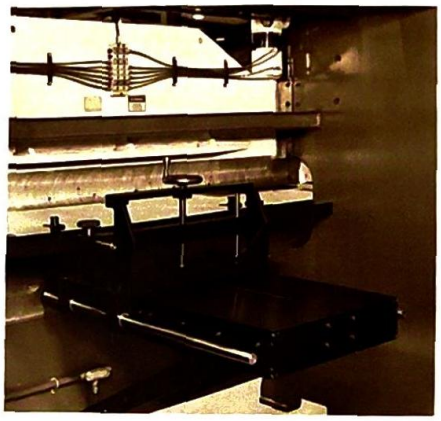
DRC Automatic Back Gauge System For Press Brakes.



1 STEP
1 CYCLE
017.36 DIMENSION
0.12 BEND ALLOW
4 DEPTH
IN MM
DRC
STEP
IDLE
RUN
CYCLE
DEPTH
BEND ALLOW
CLEAR
SEQ
STOP

The DRC Automatic Back Gauge System.

Why Automatic Back Gauge?
By automatically power positioning the Back Gauge to the required dimension, a job can be completed with one handling of the material. Time consuming set-up for each bend is eliminated. A complete piece with all the different bends can be made the first time through and inspected before the entire lot is run. All of this results in an increase in throughput, productivity and savings.



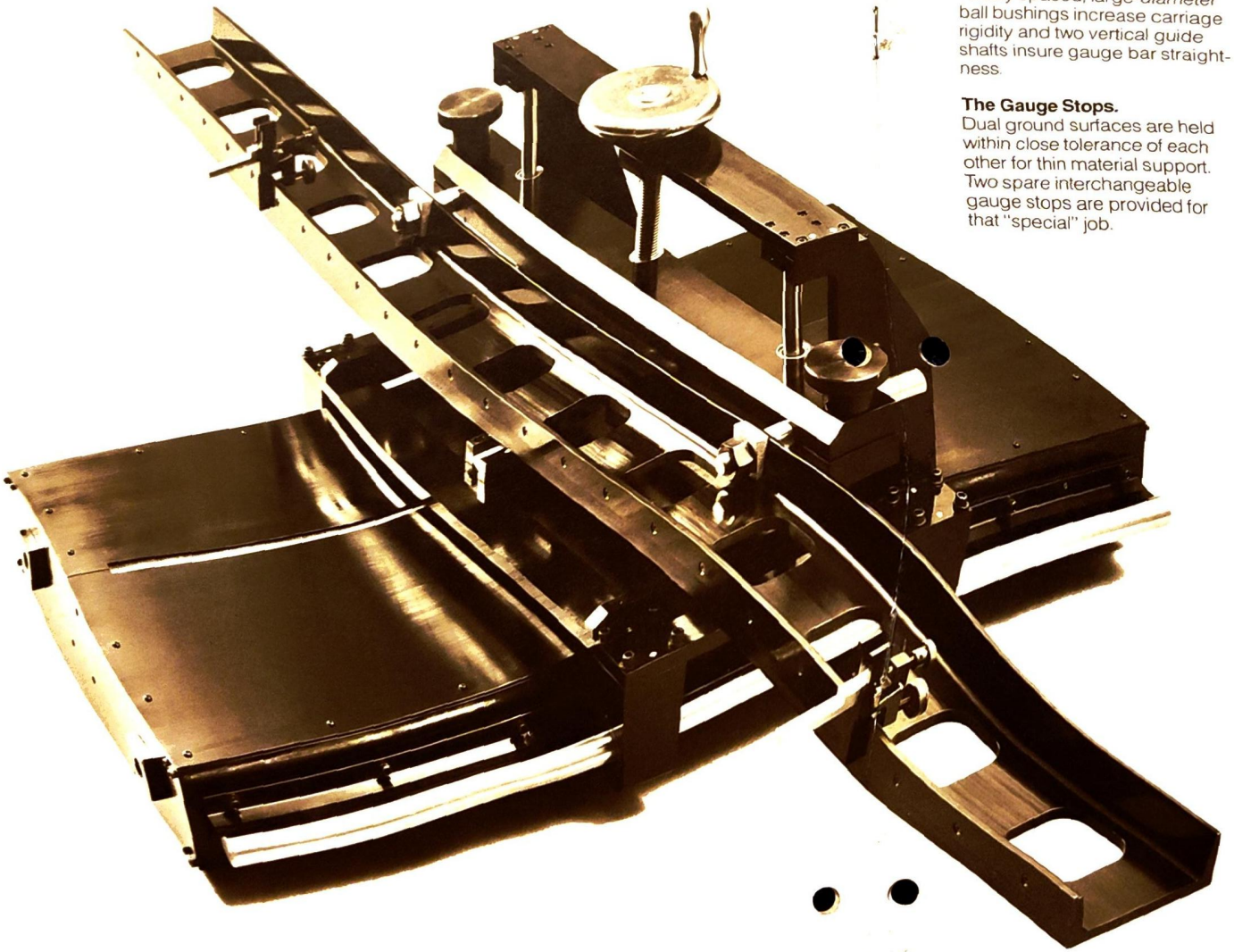
Why a DRC Automatic Back Gauge?
The DRC Back Gauge controller has the capacity to store up to 72 different dimensions. As many as 9 different programs can be stored in memory, ready for recall any time, for the repeat job. Inches are converted to millimeters and millimeters are converted to inches at a flip of a switch.

The DRC Back Gauge is built for rugged duty with the highest accuracy. The direct drive motor system eliminates errors associated with pully coupled systems. The direct reading linear encoder insures repeatable and accurate dimensions. Backlash is eliminated. The gauge bar can be vertically positioned with a single wheel providing smooth operation. Spring returned flip-up gauge stops are provided for reverse bends.

Very simple to use.
The operator enters the bend number, dimension, bend allowance, and depth.* Push button switches light up in sequence to lead you through the programming. In the Enter mode, a push of the Sequence button provides sequential display of the bend dimensions for final check. A push of the Sequence button in the Run mode, automatically positions the Back Gauge to the new dimension after each bend is made.

*When used in conjunction with brakes equipped with electrical switches for multiple depth settings.

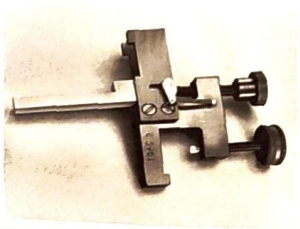
The Back Gauge Mechanism



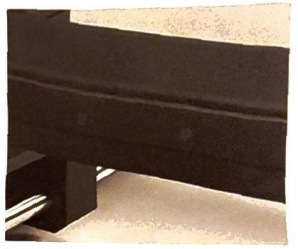
Designed throughout for rugged service.
Maintains specified accuracy even when a 100 pounds of force is applied to the Gauge Bar. The carriage is flexure-driven to isolate motor vibration and provide smooth operation. Widely spaced, large-diameter ball bushings increase carriage rigidity and two vertical guide shafts insure gauge bar straightness.

The Gauge Stops.
Dual ground surfaces are held within close tolerance of each other for thin material support. Two spare interchangeable gauge stops are provided for that "special" job.

The Motor Drive.
A flexible motor-to-shaft coupler eliminates vibration and wear. Mechanical and electrical stops prevent overtravel. The closed-loop servo is controlled by a direct-reading linear encoder to insure position accuracy and repeatability.

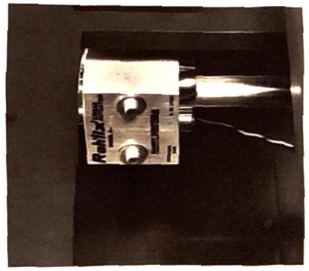


Fast calibration. Fine adjustment screw provides speedy, accurate gauge stop calibration and spring-return flip-up gauge stops accommodate reverse bends.

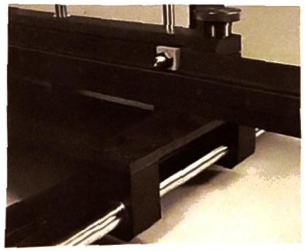


Resists damage. Hardened and ground steel reference surface on the face of the gauge bar resists damage when struck by the work piece.

High accuracy. Direct motor drive insures accuracy and eliminates backlash and slippage errors common in coupled drives.



Shock-proof. Linear actuator provides over-load protection against sudden shocks.



Quick, easy set-up. Accomplished by a coarse adjustment screw for the gauge bar and a fine adjustment screw for the gauge stops. Preloaded thrust bearings eliminate bearing lock and insure accuracy and stiffness.

Repeatability. Closed-loop servo is controlled by direct-reading linear encoder to insure position accuracy and repeatability.

The Back Gauge Controller

Program storage.
Memory stores up to nine different programs for instant recall on repeat orders, and up to 72 different dimensions. Instant calculation of inches to millimeters or millimeters to inches is provided with the flip of a switch.

Illuminated Mode Buttons.
Makes programming easy by indicating which mode has been selected (ENTER, IDLE, CALIBRATE, RUN) and what type information is expected.

Easy correction feature.
Provides addition (+) and subtraction (–) of dimensions or bend allowances for easy correction during the first-piece trial run.

Modes of operation.
Illuminated buttons indicate the following modes:

ENTER. Provides entry of up to 72 dimensions.

IDLE. Positions Back Gauge to the selected bend and allows changes of dimension for first-piece trial run.

CALIBRATE. Aligns back gauge during start-up.

RUN. Automatically positions the back gauge to next dimension after each bend.

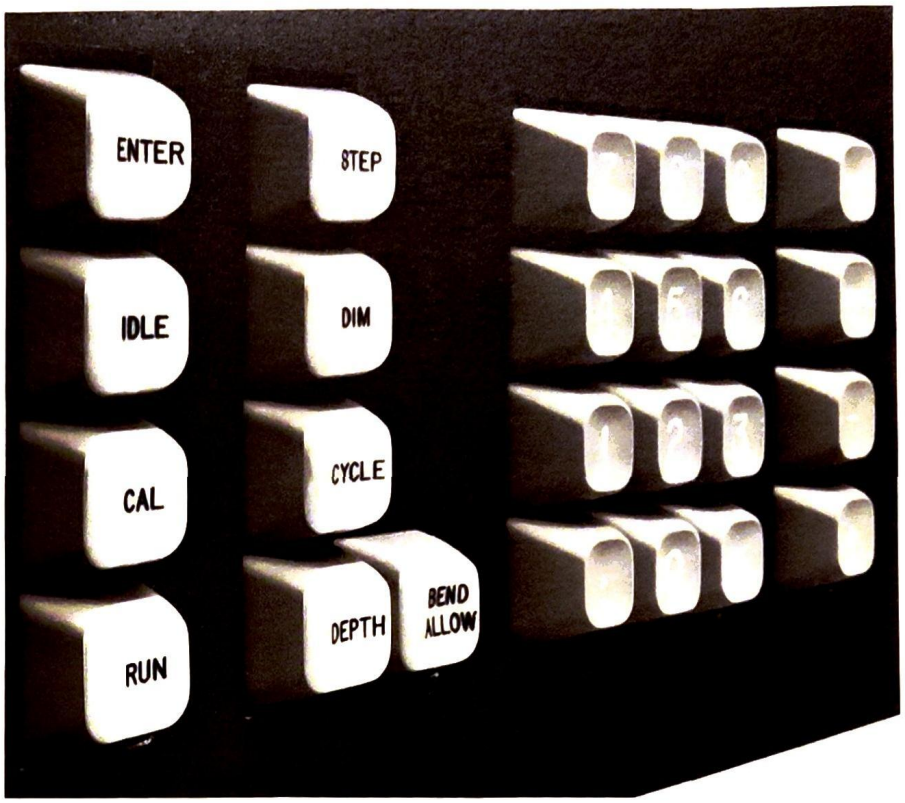
STEP. Identifies the bend number.

DIMENSION. Provides entry of the desired dimension for the bend.

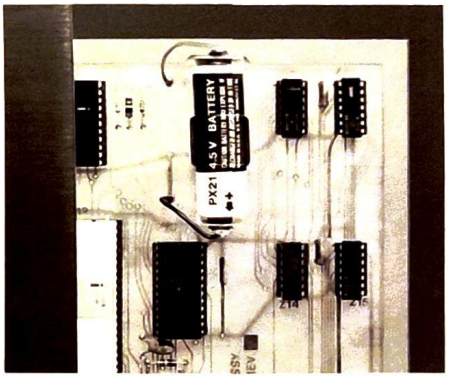
CYCLE. Provides up to 9 repeats of one dimension.

BEND ALLOWANCE. Causes the gauge to position to the programmed dimension minus the bend allowance.

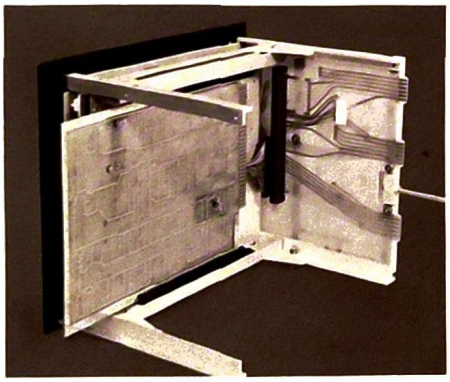
DEPTH. Provides signals for up to 9 different contact closures for brakes equipped with multiple depth settings.



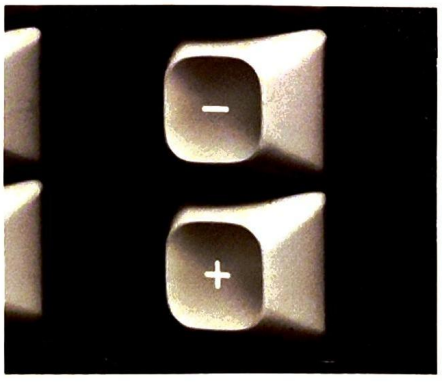
Long-life displays. Solid-state LED displays guarantee long life and assures a minimum of failures.



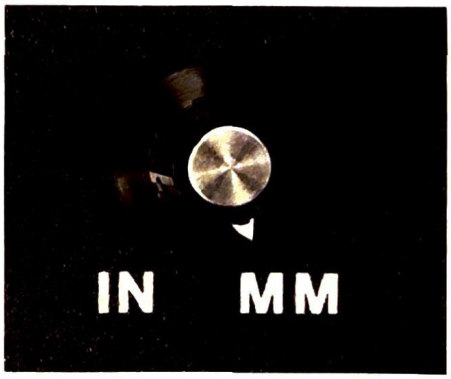
Fail-safe. Standard rechargeable battery pack prevents loss of programs for a minimum of two weeks if power failure occurs.



Easy maintenance. Plug-in components. Controller can be taken apart by hand. No soldering necessary.



+ and – buttons. Provides addition and subtraction of dimensions and bend allowances for easy correction during the first-piece trial run.



Instant calculation. Inch to millimeter or millimeter to inch.

Precision Measurement Division

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- Inspection
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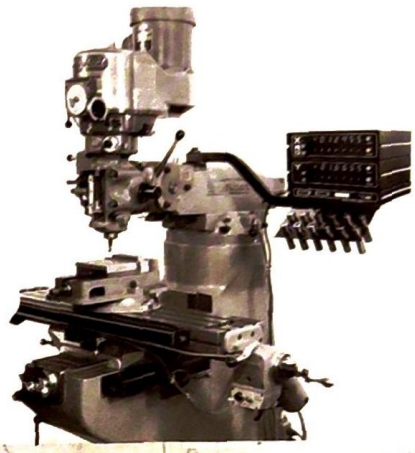
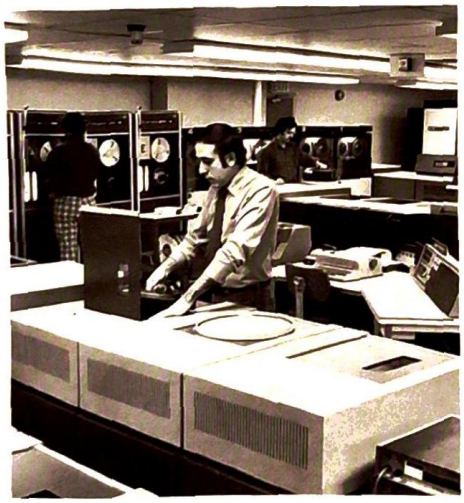
- Regional Support by Factory Personnel

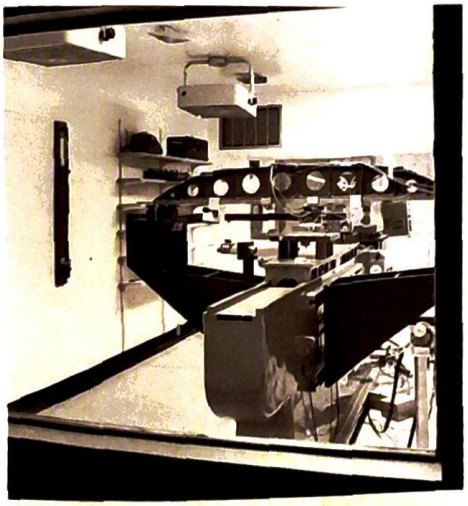
Over the past 21 years, our reputation for quality, service and experience has won us acceptance in the control and digitization of linear and rotary motion for virtually any position application.

Warranty

DRC warrants the Automatic Back Gauge against defects in material and workmanship under normal and proper use and service for a period of one year on both parts and labor.







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